

Work Order ID 67527 - 2

Splts



Monday, March 28, 2011 9:06:54 AM

Page 1

Item ID: D3319-3

Accept



Setup



Revision ID:

Item Name: Wearplate

Stop



Start Date: 3/28/2011

Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011

Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 1/28/2011

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00



FLOW WATER JET

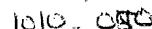
Waterjet

Memo

0.00

1/28/2011

FLOW CNC Waterjet



I-Cut as per Dwg D3319

Dwg Rev: 8

Prog Rev: 8

2-

Deburr if necessary

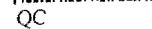


110

QC2- Inspect parts off machine FAI/FAIB

0.00

1/28/2011



Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

1/28/2011



Memo

0.00

Quality Control

1/28/2011

Ship 02/04

# Work Order ID 67527



Page 3

Monday, March 28, 2011 9:06:54 AM

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Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

160



Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev:

Qty Part Number Description Batch A/R  
N/A 7560 Hardcoat Rod 20117139

170



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Quality Control

Memo

0.00

Subtotal

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

Subtotal

16

Work Order ID: 67527 Date: Monday, March 28, 2011 9:06:54 AM

## Work Order ID 67527

Monday, March 28, 2011 9:06:54 AM



Page 4

Item ID: D3319-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 115128.

6. BL 11-4-12

Memo

0.00

START TIME:

10:55

OVEN TEMPERATURE:

320°

FINISH TIME:

11:25

200



QC3- Inspect Part Finish

0.00

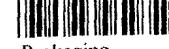
QC

Memo

0.00

6. 6 BL 11-4-12

210



Packaging

0.00

Memo

0.00

11/4/12 SP/6

Packaging

Identify on inside surface using a permanent fine point marker with the following:  
E/TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-3, B/N:  
BXXXXXX For Product Eligibility see PDA05-18 and  
Stock Location: 404

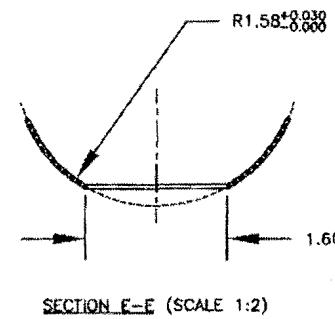
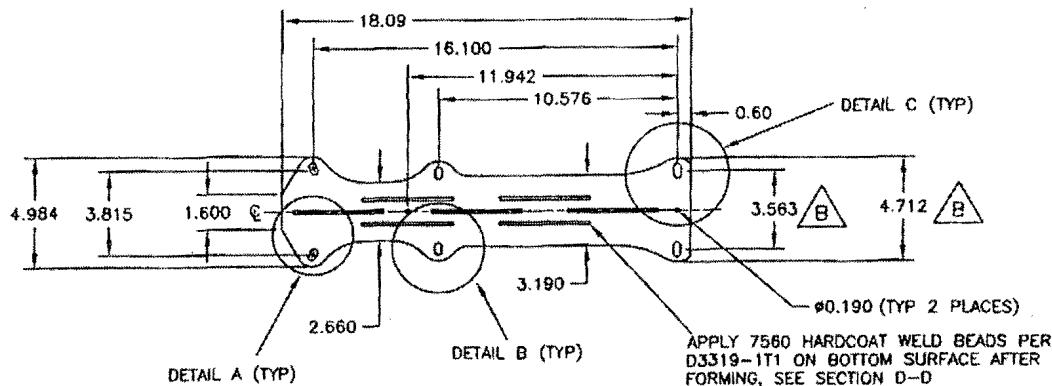
**D**  
**A**  
**R**  
STAMP COPY  
NOTES TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 67527

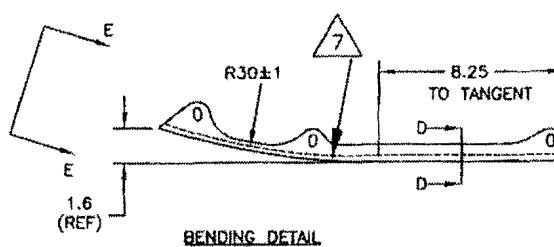
PL1103-28

DESIGN	DRAWN BY	DART AEROSPACE LTD.
P1	PL	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
11	11	D3319
DATE	TITLE	SHEET 1 OF 5
05.06.06	NEW ISSUE	SCALE
A	WEARPLATE	1:8
B	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	

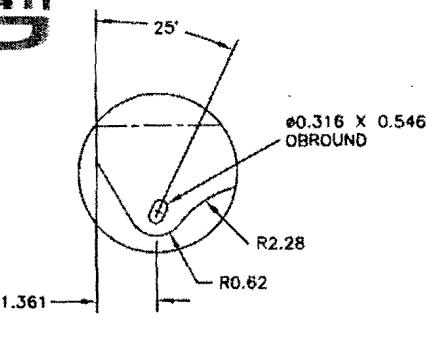
FLAT PATTERN



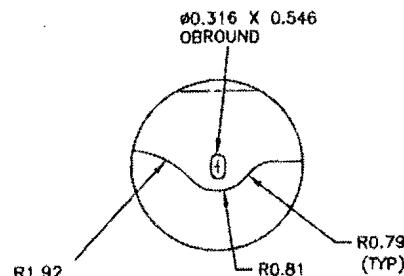
SECTION E-E (SCALE 1:2)



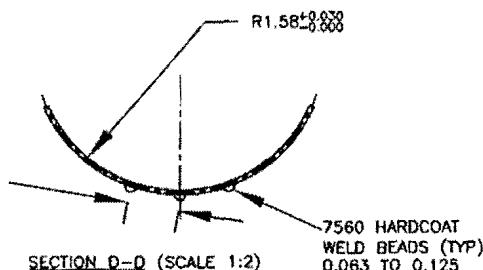
BENDING DETAIL



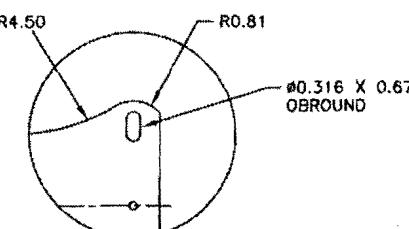
DETAIL A  
(SCALE 1:4)



DETAIL B  
(SCALE 1:4)



SECTION D-D (SCALE 1:2)

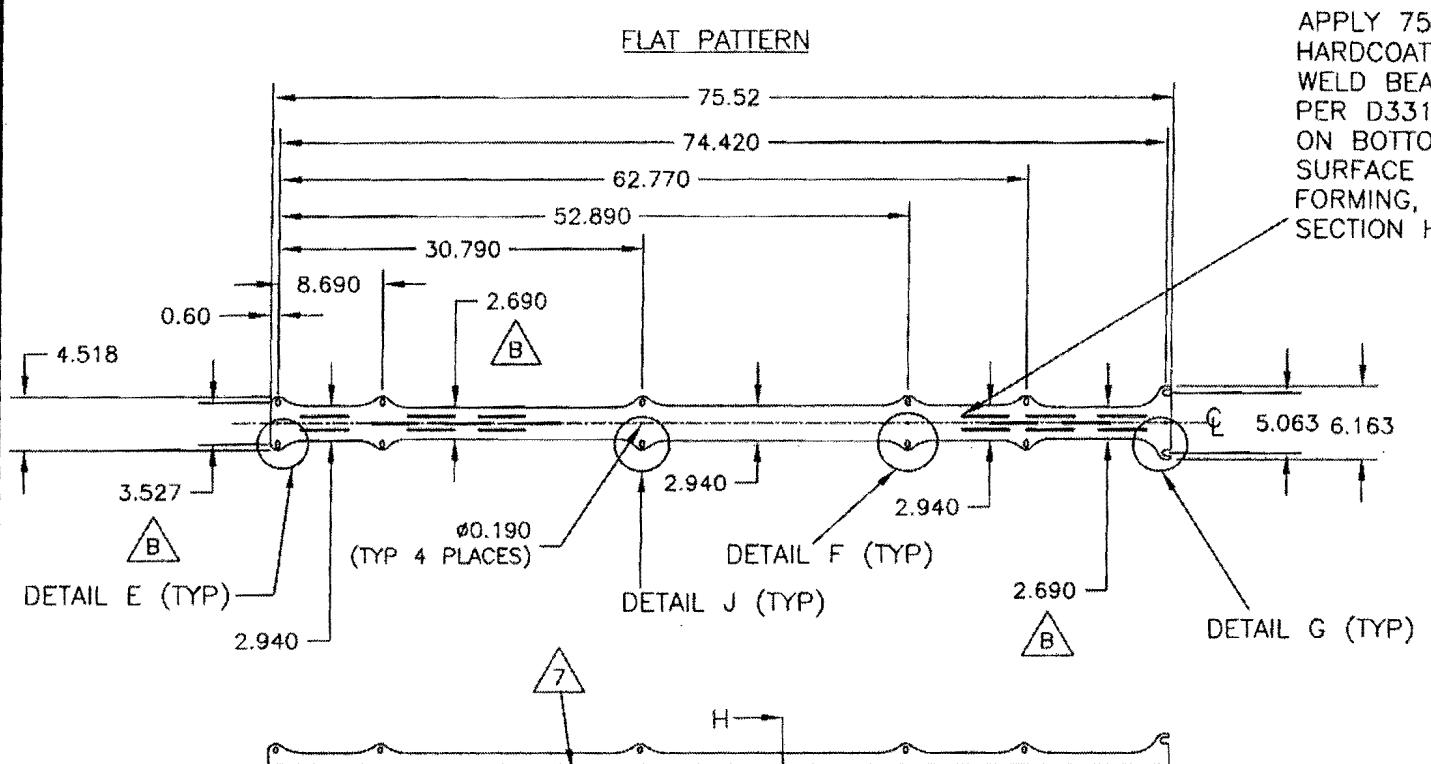


DETAIL C  
(SCALE 1:4)

D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**RELEASED**  
05.07.30



BENDING DETAIL

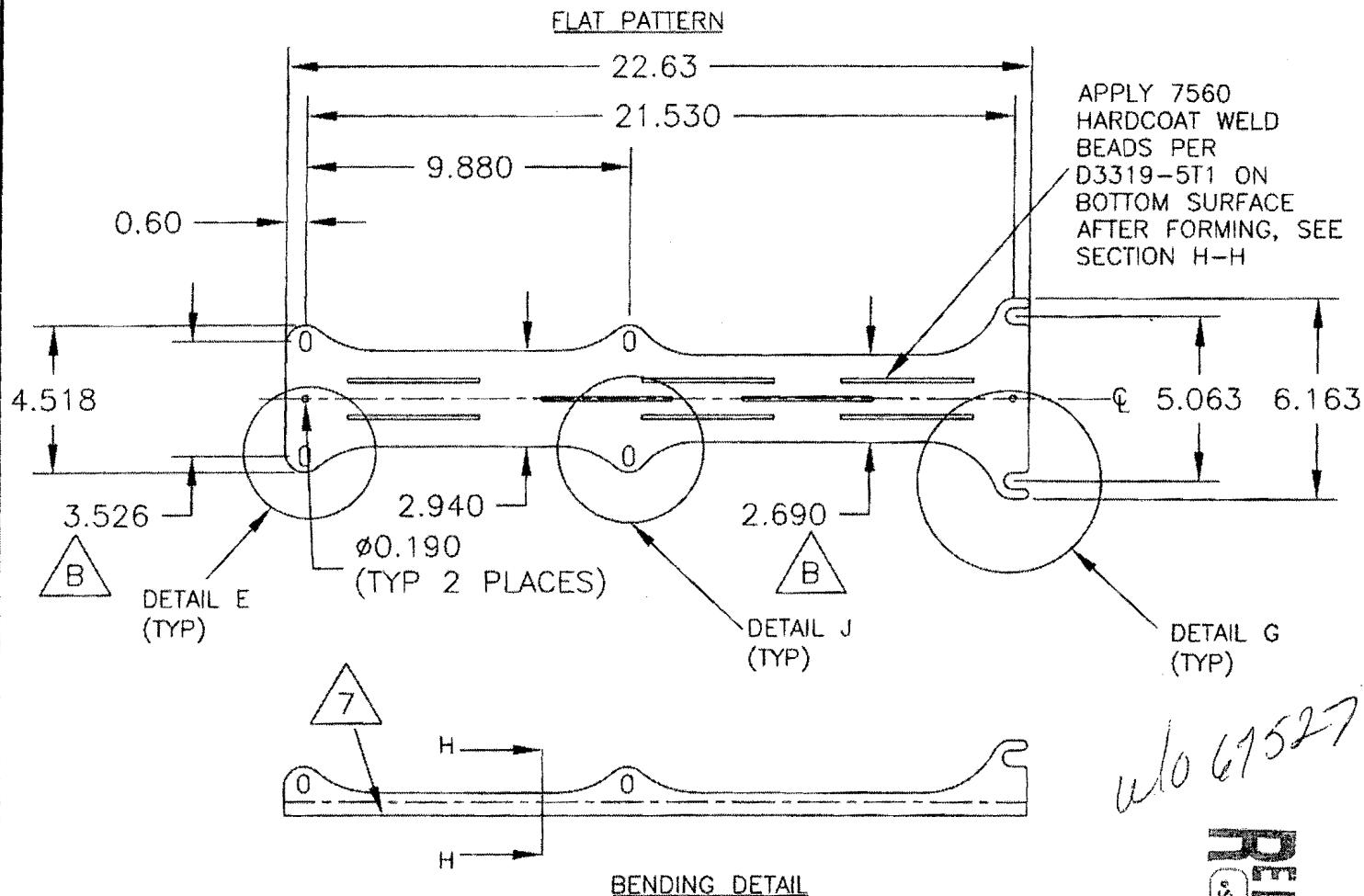
D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/06/05/27

DESIGN <i>PP</i>	DRAWN BY <i>PP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PP</i>	APPROVED <i>PP</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	REV. B SHEET 2 OF 3 SCALE 1:15
		<b>RELEASED</b> <i>PP</i>

**DART**

**DART**

W/0 61527

DESIGN #21	DRAWN BY P.H.	DART AEROSPACE LTD
CHECKED H	APPROVED H	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	SHEET 3 OF 5
		SCALE 1:5

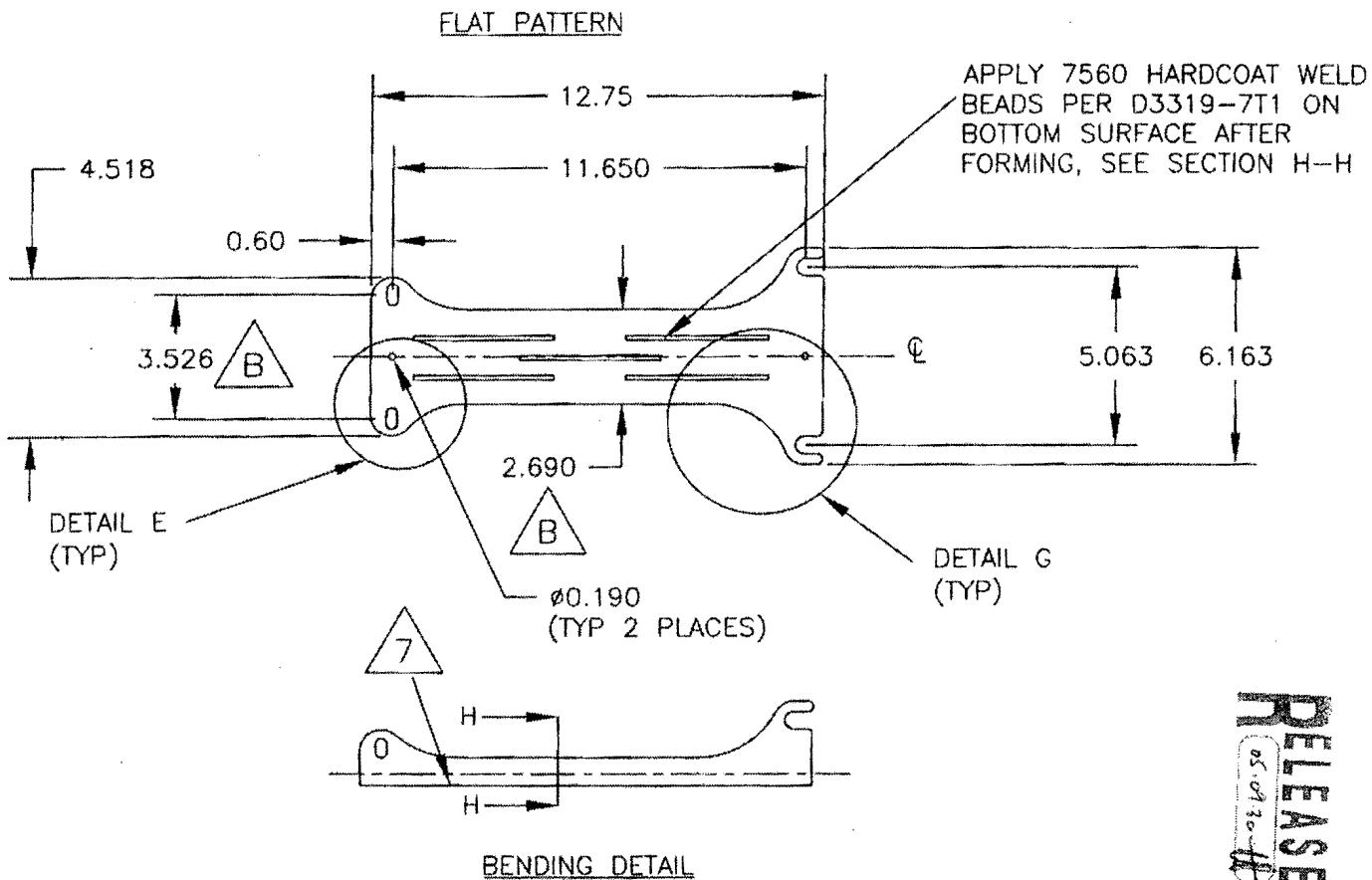
RELEASED  
05.06.06

D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	HAWKESBURY, ONTARIO, CANADA REV. B SHEET 4 OF 5
DATE 05.06.06	TITLE WEARPLATE	SCALE 1:5	

**RELEASED**  
05.06.06

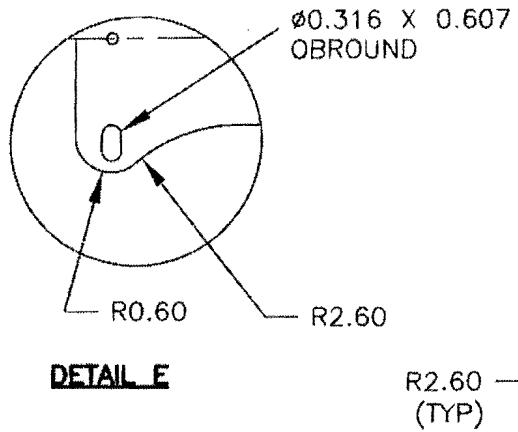
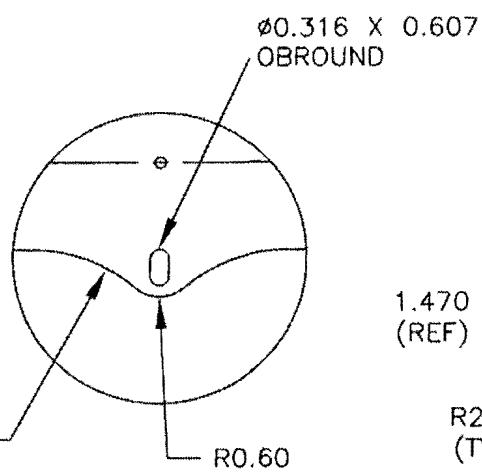
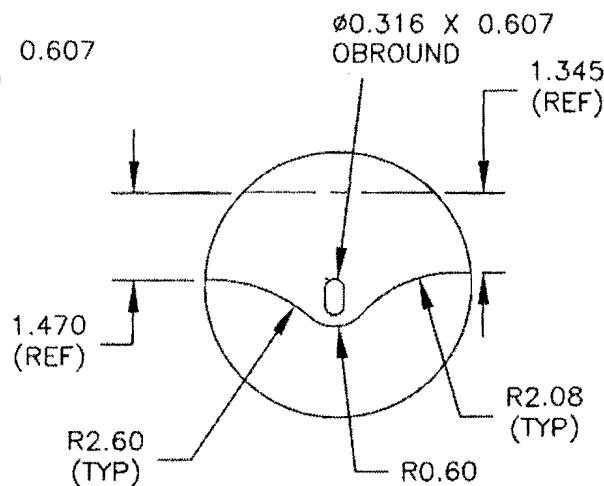
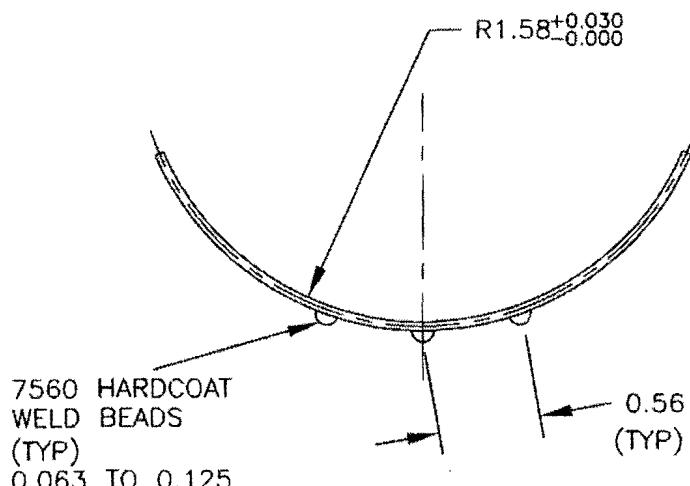
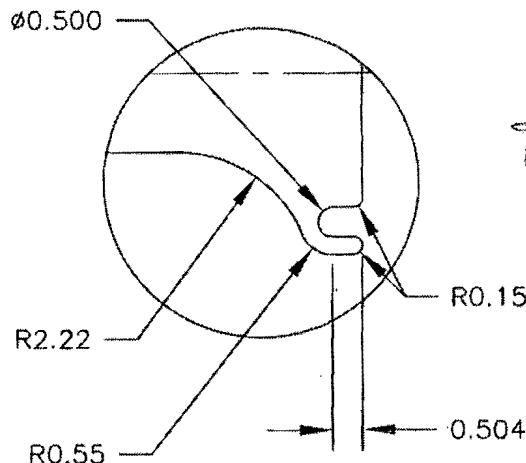
W/0 47527

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	REV. B SHEET 5 OF 5 SCALE 1:3

**DETAIL E****DETAIL F****DETAIL J****SECTION H-H  
(SCALE 1:1)****DETAIL G**

W/6 4152